

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021222**Date Inspected:** 01-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#14

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08311

Magnetic Particle Testing (MT)

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The member is identified as OBG Component. The weld designation reviewed as follows:

SEGMENT 13AE

SEG3007J-040-037; 038; 039; 040

East Side

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #130 located on 14E, SEG3019AE. Welder is identified as 068097. ZPMC Quality Control (QC)

Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the

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WPS-B-P-2213-Tc-U4b-FCM-1.

Submerged Arc Welding (SAW):

Weld joint #009 located on 13BE+13CE, OBE13A. Welder is identified as 215993. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2c-S-2. (See attached photo)

Flux Cored Arc Welding (FCAW):

Weld joint #068 located on 13AE, SEG3007AV. Welder is identified as 055491. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #077 located on 13AE, SEG3007AU. Welder is identified as 050564. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #069 located on 14E, SEG3019BB. Welder is identified as 067877. ZPMC Quality Control (QC) Inspector is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #013 located on 13AE, SEG3007AV. Welder is identified as 055491. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Weld joint #006 located on 13AE, SEG3007AU. Welder is identified as 050564. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Weld joint #113 located on 14E, anchor plate to vertical shear plate, SEG3019BB. Welder is identified as 067079. ZPMC Quality Control (QC) Inspector is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

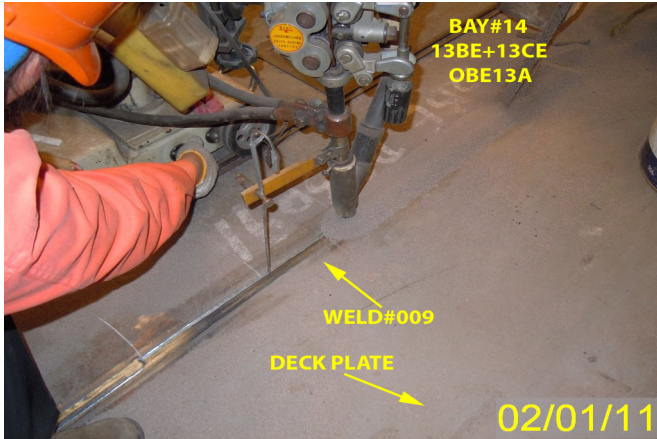
Weld joint #009 located on 13BE+13CE, OBE13A. Welder is identified as 052696. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-T-ESAB-1.

Weld joint #020 located on 13AE, SEG3007AV. Welder is identified as 055491. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
